

H Handling recommendations

Milling cutters

Adjustment instructions

for Hollfelder-Gühring milling cutters with eccentric adjustment

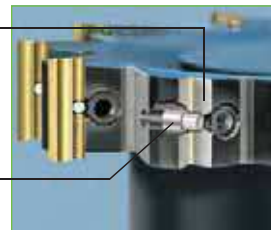
1. Loosen clamping element and clean the insert pocket properly. After the cleaning of the insert pocket the bore hole for the eccentric bolt has to be covered with E 5162 assembly paste E 5162 (copper or graphite based)

2. Put a new insert in the insert pocket.



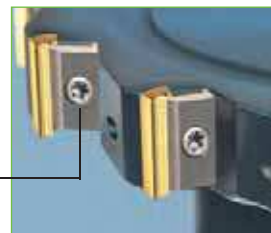
Please see that the slot in the insert „hooks into“ the eccentric bolt in the insert pocket.

Highly exact insert pocket to attach the insert



Eccentric bolt for μm -accurate adjustment of the insert

3. Softly tighten the clamping element with a Torx-screw driver and then tighten it again with the necessary **torque**. You will find the corresponding **torque wrench** as well as the torx-bits on page 31.



4. By means of the adjustment key (hex key) the cutting edges can be adjusted either towards each other and /or with regard to a specific length dimension. The adjustment system allows a continuous adjustment. All inserts have to be adjusted to the maximum length possible first and then towards each other or to be desired measure.

5. It is important that the adjustment is always only effected in one direction! If an unintended excessive or inferior adjustment occurs you only have to make another whole turn with the eccentric bolt.

6. **It is not necessary to retighten the clamping element!**
The tool can now be used.



Adjustment key (hex key) to work the eccentric bolt

Security advice: For security reasons the milling cutter must be returned to the manufacturer for inspection if the holder is damaged! The clamping sets must be renewed on a regular basis or in case that they show any sign of damage. Only original spare parts may be used!

Torque for clamping elements

Tool Type	Clamping set	Torque (Ncm)	Torx size
H 3108	E 4265	70	Tx 6
H 6120	E 4119	140	Tx 8